

## **AMENDMENT(S) TO THE SPECIFICATION**

**Please replace the paragraph beginning at page 1, line 12, with the following rewritten paragraph:**

Brassieres which incorporate a breast cup construction of a moulded  molded or mouldable  moldable material are becoming more prevalent. One of the advantages that is brought about by a moulded  molded breast cup construction is a more simplified method of manufacture. Normally a moulded  molded breast cup construction will reduce the number of panels required to define the breast cup since the three dimensional cup form can be formed by a moulding  molding step. Traditionally cups have been formed by the stitching of a plurality of panels together to define the three dimensional cup form.

**Please replace the paragraph beginning at page 1, line 19, with the following rewritten paragraph:**

However, the provision of a breast cup construction of a basic moulded  molded form has a reasonably plain appearance. Unlike the traditionally multi panel sewn form of cup constructions, the moulded  molded cup form generally consists of a single panel of material and in general does not incorporate significant detailing to enhance the appearance of the breast cup. Furthermore since the breast cup is of a moulded  molded construction it can be difficult to add any enhancements to the breast cup construction after it has been formed. Furthermore, prior to forming, the pre form sheet materials do not conveniently lend themselves to the addition of enhancements which can, along with the pre form, be conveniently moulded  molded to define a suitable breast cup shape.

**Please replace the paragraph beginning at page 2, line 5, with the following rewritten paragraph:**

In a first aspect the present invention consist in a method of making a breast cup for a garment of clothing comprising:-

a) taking a structure defining component of a breast cup form and created from a flexible sheet of mouldable  moldable material,

b) engaging a flexible covering panel (herein after "covering panel") of an at least part breast cup form corresponding to at least part of said structure defining component, to the structure defining component to locate said covering panel on the convex side of the breast cup form of said structure defining component in at least a partial overlapping condition, to thereby define a panel assembly which includes said structure defining component and said covering panel

c) affixing to the convex side of said panel assembly, a panel of flexible decorative material (herein after "decorative panel") of a contrasting appearance to the convex side of said covering panel in an overlying condition to part of said panel assembly and in a position to locate said decorative panel inwardly of the perimeter of said panel assembly,

d) removing a region of the panel assembly covered by and within the perimeter of said decorative panel to thereby expose the decorative panel to the concave side of said panel assembly.

**Please replace the paragraph beginning at page 4, line 7, with the following rewritten paragraph:**

In a further aspect the present invention consist in a method of making a breast cup for a garment of clothing comprising:-

a) taking a structure defining component of a breast cup form and created from a flexible sheet of mouldable moldable material,

b) engaging a flexible panel (herein after "covering panel") of an at least part breast cup form corresponding to at least part of said structure defining component, to the structure defining component to locate said covering panel on the convex side of the breast cup form of said structure defining component in at least a partial overlapping condition, to define a panel assembly which includes said structure defining component and said covering panel

c) affixing to the concave side of said panel assembly, a panel of flexible material (herein after "decorative panel") of a contrasting appearance to the convex side of said covering panel in an overlying condition to part of said panel assembly and in a position to locate said decorative panel inwardly of the perimeter of said panel assembly,

d) removing a region of the panel assembly covered by and within the perimeter of said decorative panel to thereby expose the decorative panel to the convex side of said panel assembly.

**Please replace the paragraph beginning at page 4, line 23, with the following rewritten paragraph:**

In a further aspect the present invention consist in a breast cup assembly comprising a structure defining component of a breast cup form and created from a flexible sheet of mouldable  moldable material,

a flexible panel (herein after "covering panel") affixed to said structure defining component and of an at least part breast cup form corresponding to at least part of said structure defining component, said covering panel located adjacent the structure defining component on the convex side of said structure defining component and in an at least a partial overlapping condition with said structure defining component, to define a panel assembly which includes said structure defining component and said covering panel

a panel of flexible material (herein after "decorative panel") of a contrasting appearance to the convex side of said panel assembly and affixed with, at either one side selected from said convex side and concave side, said panel assembly in an overlying condition and located in a position inwardly of the perimeter of said panel assembly,

wherein an opening is provided through said structure defining component at a region of the structure defining component encompassed by the perimeter of said decorative panel to there through expose the decorative panel to the opposite of said one of said convex side and concave side of said structure defining component.

**Please replace the paragraph beginning at page 5, line 14, with the following rewritten paragraph:**

Preferably said structure defining component includes a moulded  molded sheet of foam material with which there is affixed to each opposed major surface, a panel of fabric.

**Please replace the paragraph beginning at page 5, line 29, with the following rewritten paragraph:**

In a further aspect the present invention consist in a method of making a breast cup for a garment of clothing comprising:-

- a) taking a structure defining component of a breast cup form and created from a flexible sheet of mouldable molded material,
- b) affixing at a convex side region and in an overlying condition to said structure defining component, a panel of flexible material (herein after "decorative panel") of a contrasting appearance to the convex side of said structure defining component, said affixing being of a position to locate said decorative panel inwardly of the perimeter of said structure defining component,
- c) removing a region of said structure defining component to create an opening through said structure defining component, said opening of a region corresponding to and inwardly of the perimeter of said decorative panel to thereby expose the affixed decorative panel to the concave side of said structure defining component.

**Please replace the paragraph beginning at page 6, line 23, with the following rewritten paragraph:**

In a further aspect the present invention consist in a method of making a breast cup for a garment of clothing comprising:-

- a) taking a structure defining component of a breast cup form and created from a flexible sheet of mouldable molded material,
- b) affixing at a concave side region and in an overlying condition to said structure defining component, a panel of flexible material (herein after "decorative panel") of a contrasting appearance to the convex side of said structure defining component, said affixing being of a position to locate said decorative panel inwardly of the perimeter of said structure defining component,
- c) removing a region of said structure defining component to create an opening through said structure defining component, said opening being inwardly of the perimeter of said decorative panel to thereby expose the affixed decorative panel to the convex side of said panel assembly.

**Please replace the paragraph beginning at page 7, line 18, with the following rewritten paragraph:**

In a further aspect the present invention consist in a breast cup assembly comprising a structure defining component of a breast cup form and created from a flexible sheet of mouldable  moldable material,

a panel of flexible material (herein after "decorative panel") of a contrasting appearance to the convex side of said structure defining component affixed with, at either one side selected from said convex side and concave side, said structure defining component in an overlying condition and located in a position inwardly of the perimeter of said structure defining component,

wherein an opening is provided through said structure defining component at a region of the structure defining component encompassed by the perimeter of said decorative panel to there through expose the decorative panel to the opposite of said one of said convex side and concave side of said structure defining component.

**Please replace the paragraph beginning at page 8, line 4, with the following rewritten paragraph:**

In a further aspect the present invention consist in method of making a breast cup for a garment of clothing comprising:-

a) taking a structure defining component of a breast cup form and created from a flexible sheet of mouldable  moldable material,

b) engaging a flexible panel (herein after "covering panel") of an at least part breast cup form corresponding to at least part of said structure defining component, to the structure defining component to locate said covering panel on the convex side of the breast cup form of said structure defining component in at least a partial overlapping condition, to thereby define a panel assembly which includes said structure defining component and said covering panel, said covering panel including on the convex side of said covering panel, a panel of flexible material (herein after "decorative panel") of a contrasting appearance to the convex side of said covering panel, positioned in an overlying condition to said covering panel and in a position to locate said decorative panel inwardly of the perimeter of said covering panel,

[[d]] c) removing a region of the panel assembly within a corresponding region of said panel assembly encompassed by the perimeter of said decorative panel to thereby expose the decorative panel to the concave side of said panel assembly.

**Please replace the paragraph beginning at page 8, line 20, with the following rewritten paragraph:**

In a further aspect the present invention consist in a method of making a breast cup for a garment of clothing comprising:-

a) taking a structure defining component of a breast cup form and created from a flexible sheet of ~~mouldable~~ moldable material,

b) engaging a flexible panel (herein after "covering panel") of an at least part breast cup form corresponding to at least part of said structure defining component, to the structure defining component to locate said covering panel on the concave side of the breast cup form of said structure defining component in at least a partial overlapping condition, to thereby define a panel assembly which includes said structure defining component and said covering panel, said covering panel including on the concave of said covering panel, a panel of flexible material (herein after "decorative panel") of a contrasting appearance to the convex side of said structure defining component, positioned in an overlying condition to said covering panel and in a position to locate said decorative panel inwardly of the perimeter of said covering panel,

[[d]] c) removing a region of the panel assembly within a corresponding region of said panel assembly encompassed by the perimeter of said decorative panel to thereby expose the decorative panel to the concave side of said panel assembly.

**Please replace the paragraph beginning at page 9, line 14, with the following rewritten paragraph:**

Figures 1 - 14 illustrate the preferred steps to the method of the invention for defining the breast cup construction of Figure 15, wherein

Figure 1 is a perspective view of a sheet of material to provide the structure defining component of the breast cup construction prior to being ~~moulded~~ molded,

Figure 2 is a side sectional view of a moulding molding device to mould mold two cup forms in the sheet of Figure 1,

Figure 3 is a plan view of part of the sheet of Figure 1 after moulding molding in the moulding molding device of Figure 2,

Figure 4 is a detailed side sectional view of the upper mould mold portion of the mould mold of Figure 2,

Figure 5 is a perspective view of a cover sheet to be incorporated with the structure defining breast cup portions,

Figure 6 is a side view of a moulding molding device for moulding molding a breast cup form in the sheet of material of Figure 5,

Figure 7 is a perspective view of the sheet of Figure 5 engaged with a framing device which may be utilised utilized for supporting the sheet of Figure 5 during the moulding molding phase provided by the moulding molding device of Figure 6,

Figure 8 is a plan view of the moulded molded form of Figure 1 wherein the moulded molded cup forms are to be cut from the remaining portions of the sheet,

Figure 9 is a sectional view through a breast cup construction assembly comprising of the structure defining breast cup component and the breast cup component defined from the sheet of Figure 5 engaged together,

Figure 10 illustrates a sewing of the structure defining breast cup component and the breast cup defined from Figure 5 together to define an outline by stitching on the convex side of the breast cup assembly,

Figure 11 illustrates the sewing of a panel of contrasting appearance on to the convex side of the breast cup assembly,

Figure 12 is a front view of the breast cup assembly defined by the step of Figure 11,

Figure 13 illustrates the removal of a region of the breast cup assembly to thereby expose the panel of contrasting appearance on the concave side,

Figure 14 illustrates an embroidery step for enhancing the appearance of the breast cup assembly, but which may have alternatively been previously defined with reference to the step of Figure 11,

Figure 15 is a front view of a breast cup construction of the present invention, Figure 15A which is a brassiere which incorporates breast cup constructions as defined with reference to Figure 15,

Figure 16 is a sectional view of the structure defining component of the breast cup assembly engaged with the covering sheet prior to being manipulated to define the preferred relationship between the structure defining component and the covering sheet,

Figure 17 is a sectional view wherein the cover sheet and the structure defining component of Figure 16 have been manipulated to define the preferred form of their relationship which will lead to the constructional relationship as shown in Figure 9, and

Figure 18 is an alternative to the breast cup assembly of Figure 15.

**Please replace the paragraph beginning at page 10, line 27, with the following rewritten paragraph:**

With reference to Figure 15, the present invention includes a method to define a breast cup assembly similar to the kind as shown in Figure 15. The breast cup assembly 1 is substantially of a breast cup shape and made substantially from ~~mouldable~~ moldable materials.

**Please replace the paragraph beginning at page 11, line 27, with the following rewritten paragraph:**

Figure 1 illustrates a sheet 10 of flexible and ~~mouldable~~ moldable material which is used to define the structure defining component 31 to the breast cup assembly 1. A sheet 10 is of a perimeter size sufficient for at least one cup form to be ~~moulded~~ molded therein. In the most preferred form the sheet is of a perimeter sufficient to allow for two matching cup forms (left and right side) to be formed in the sheet simultaneously by a two cup ~~moulding~~ molding machine, as for example shown in part in Figure 2. The sheet 10 preferably consists of three layers of material. The first layer 11 is a sheet layer of foam 11 such as, for example polyurethane. In its ~~pre-moulded~~ pre-molded form, the sheet of foam 11 is for example of a thickness of 5mm. The sheet of foam 11 has engaged to each of its opposed major surfaces, layers of thin flexible sheet such as a fabric material 12, 13. The layers of fabric material 12, 13 are adhered preferably directly to the opposing major surfaces of the

sheet of foam 11. Such adhesion may be by heat welding and/or adhesive affixing. The sheet 10 is preferably cut from a bulk supply of material to define the sheet and accordingly the fabric layers 12, 13 are substantially co-extensive with the sheet of foam 11. The layers of fabric 12, 13 are preferably of a woven fabric, however alternatively the layers 12, 13 are of a non-woven kind. All plies of the sheet 10 are of a synthetic and mouldable  moldable material.

**Please replace the paragraph beginning at page 12, line 14, with the following rewritten paragraph:**

The sheet 10 has a moulded  molded cup form or forms introduced therein by a moulding molding device as, for example, in part shown in Figure 2. The moulding molding device includes an upper mould  mold portion 17 and a lower mould  mold portion 18. It can be seen in the arrangement of Figure 2 that the upper mould  mold portion includes convex moulding molding surfaces and the lower mould  mold portion includes substantially complimentary shaped concave moulding molding surfaces to introduce two, three dimensional cup forms into the sheet 10 of the Figure 1.

**Please replace the paragraph beginning at page 12, line 20, with the following rewritten paragraph:**

Preferably although not essentially, the moulding molding step to define the moulded  molded cup form(s) in the sheet 10 of Figure 1 also includes the provision of an embossed or depressed relief to the concave side of the moulded  molded cup form(s). Such embossing is preferably provided by an upstanding region 19 of at least one of the convex cup moulding molding surfaces of the upper mould  mold 17.

**Please replace the paragraph beginning at page 12, line 25, with the following rewritten paragraph:**

Preferably where both cups to be incorporated into the bra are to include the panel 6 as shown in Figure 15 then both convex up stands of the upper mould  mold portion should include the upstanding surface 19. Since the panel 6 is to be incorporated into the cup form within the

boundaries 2, 3, 4 of the perimeter of the cup, the embossing defining upstanding portion 19 provide an embossed region which preferably defines an enclosed region to the concave side of the cup shapes formed in the sheet 10.

**Please replace the paragraph beginning at page 12, line 31, with the following rewritten paragraph:**

With reference to Figure 3, the embossed region 20 is defined by the moulding molding device within the perimeter defined by edges 2, 3 and 4 of the cup forms of the sheet 10. In the examples shown in Figure 3, the embossing is of a track like form which defines the perimeter to the region 22 bounded by the embossing. Such a track form is for example, able to be defined by an upstanding track like region 19 of the upper mould mold 17 as shown in Figure 4.

**Please replace the paragraph beginning at page 13, line 3, with the following rewritten paragraph:**

In an alternative form the entire region 22 is embossed or depressed and such may be provided by an upstanding region which is entirely upstanding from the cup defining surface 25 of the upper mould mold portion 17. In effect the embossing step reduces the thickness of the panel 10 by compressing the sheet 10 and in particular the foam 11 of the sheet at regions of embossing to an extent greater than the remaining regions of the sheet 10 within the moulded molded breast cup form. The embossed relief is for example shown in Figure 9. The provision of the embossed relief to the concave side of the breast cup form of the sheet 10 is not essential but is preferred for the purposes of allowing for duplicated and repeatable placement of the panel 6 with the convex side of the cup form. The purposes of the embossing to allow for such consistent placement will become apparent as the steps to the method are further explained.

**Please replace the paragraph beginning at page 13, line 13, with the following rewritten paragraph:**

Once the cup form(s) are moulded molded in the sheet 10 the cup form(s) may be cut from the remainder of the sheet 10 as for example shown in Figure 8.

**Please replace the paragraph beginning at page 13, line 15, with the following rewritten paragraph:**

In the most preferred form the cup forms are cut from the remainder of the sheet 10 prior to the engagement of a covering panel 30 to the structure defining component 31 of the cup forms defined from the then moulded molded sheet 10. However it may be possible to engage the covering panel 30 to the structure defining component 31 whilst still engaged to the remainder of the foam sheet 10. However, preferably the covering panel 30 is engaged to the structure defining component 31 once the structure defining components are removed from the remainder of the sheet 10.

**Please replace the paragraph beginning at page 13, line 22, with the following rewritten paragraph:**

The covering panel 30 is preferably disposed from the convex side of the structure defining component 31. The cover panel 30 is preferably defined from a sheet of mouldable  moldable flexible material as for example shown in Figure 5. The flexible sheet 30 is preferably of a single ply material such as a fabric material. It is preferably made from a synthetic material such as a nylon/lycra® spandex blend of 86% nylon and 14% lycra® spandex.

**Please replace the paragraph beginning at page 13, line 27, with the following rewritten paragraph:**

In order to ensure that the covering panel (covering fabric) 30 can conveniently conform to the three dimensional cup shape of the structure defining component 31, the covering fabric 35 is preferably moulded molded to a three dimensional cup form substantially commensurate with the three dimensional cup form of the structure defining component 31 to which it is to be engaged. The covering fabric may for example be moulded molded in a moulding molding device as for example in part shown in Figure 6, the device providing two moulded molded cup forms into a single sheet of covering fabric 35. For the purposes of such moulding molding step the fabric sheet 35 may need to be engaged with a frame 36 which will hold the perimeter of the fabric sheet 35 in position during the moulding molding process to prevent the fabric sheet 35 from wrinkling during the moulding molding step.

**Please replace the paragraph beginning at page 15, line 5, with the following rewritten paragraph:**

In an alternative form of the present invention however the embossing may not be provided for the purposes of generating the cup assembly 1 of Figure 15. It may be that approximate positioning by line of sight by the operator of a sewing machine may be sufficient to generate a desired result. However for mass production the repeatability of positioning is preferred and accordingly the embossing and stitch through steps to define the reference stitching 49 is preferred. It is however anticipated by the inventor that alternative forms of defining a reference point on the convex side of the panel assembly is achievable. However, it is most preferred that any means for defining the reference points are introduced at the moulding molding steps and not on the perform sheet 10. This is because during the moulding molding step movement of the material as a result of the moulding molding may not be predictable. Accordingly any screen printing or other marking provided on a surface of the sheet 10 may not end in a repeatable position on the cup form once the sheet has been rolled. Accordingly it is believed by the inventor to be most reliable to introduce a means for defining the reference (i.e.; the embossing) during the moulding molding phase.

**Please replace the paragraph beginning at page 18, line 3, with the following rewritten paragraph:**

The moulding molding the sheet 10 in the moulding molding device of Figure 2 may for example occur where the upper mould mold is of approximately 101°C and the lower mould mold is approximately under 95°C. The moulding molding time for such temperatures and the preferred materials will be for a period of about 120 seconds. The moulding molding of the fabric panel 35 preferably occurs where the temperatures of the upper mould mold is approximately 208°C and the lower mould mold is 215°C. The moulding molding or dwell time is approximately 80 seconds.

**Please replace the paragraph beginning at page 18, line 9, with the following rewritten paragraph:**

An alternative to the method of constructing the cup assembly of the present invention will now be described. Such an alternative is not an alternative to all the steps but to part of the process

of affixing the panel 6 with the covering fabric 30. It is anticipated that the provision of the panel 6 to the panel assembly 90 may occur at a step prior to the covering fabric 30 being engaged to the structure defining component 31. The panel 6 may be affixed to the covering fabric 30 pre or post moulding molding of the fabric sheet 35 to define the covering fabric 30. The panel 6 may be affixed to the fabric sheet 35 by sewing subsequent to which the assembly is placed in a moulding molding device to define the covering fabric with the panel engaged thereto. However such may create difficulties with respect to the position of the panel 6 and the maintaining of the structural integrity of the fabric sheet 35 to define the covering fabric 30. Since the covering fabric 30 is of a thin material the provision of the panel 6 to the covering fabric after moulding molding but prior to its engagement with the structured defining component may also not be sufficient to allow for convenient engagement thereto of the panel 6. However since it is anticipated that such a step in the process of the provision of the cup assembly may be achievable, the methods of the present invention includes this alternative step to the construction of the cup assembly.